



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D407-667-205
Job Sheet 192288



Part No: D407-667-205

Job Qty: 1 ea

Part Name: Aft Crosstube - High 407



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV G IPP Rev:C 05.09.02 Add holes for comp. w/ Bell Skids KJ/JLM IPP Rev:D Add Magnobond,Rubber Cushion,Clamps 07-02-19 JLM IPP Rev:E 08-05-22 add comment seq. 6 & QC15 & QC5 DD verf:EC IPP Rev:F 08-06-12 add comment seq. 24 DD verf:EC IPP Rev:G 08-08-19 revE per dwg DD verf:EC IPP Rev H 09.01.06 ECN 08-562 EC verf:DD IPP Rev:I 10.04.07 revise route seq. in bom DD verf:JLM IPP Rev J 11.04.26 removed abrasion strip ecn 11-551 EC verf:DD IPP REV:K 11.10.03 DEOD407-667-245-F-2 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	4/19/19		0.00 0.00	Packaging 1 - 1	
						Packaging 1 - 2	
						Packaging 1 - 3	
						Packaging 1 - 4	
						Packaging 1 - 5	
						Packaging 1 - 6	
						Packaging 1 - 7	
						Packaging 1 - 8	
						Packaging 1 - 9	
						Packaging 1 - 10	
						Packaging 1 - 11	
						Packaging 1 - 12	
						Packaging 1 - 13	
						Packaging 1 - 14	
						Packaging 1 - 15	
						Packaging 1 - 16	
						Packaging 1 - 17	
						Packaging 1 - 18	
						Packaging 1 - 19	
						Packaging 1 - 20	
						Packaging 1 - 21	
						Packaging 1 - 22	
						Packaging 1 - 23	
						Packaging 1 - 24	GP 19-04-24.
						Packaging 1 - 25	
						Packaging 1 - 26	
						Plex 3/20/19 12:49 PM Dart.lajeunesse.mari	

Plex 3/20/19 12:49 PM Dart.lajeunesse.marie



Container No: S174920



Part: D407-667-205

Job No: 192288

Serial No/Batch: S174920

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAI

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

0.1.9

					Packaging 1 - 28	
					Packaging 1 - 29	
					Packaging 1 - 30	
					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	Skidtubes - Bend - 2 - B4B	1 pcs	4/19/19	1.99 3.33	Skidtubes - Bend - B4B	
130	QC 15	1 pcs	4/19/19	0.00 0.00	QC 15 - 12	
					QC 15 - 3	
					QC 15 - 47	
					QC 15 - 49	
					QC 15 - 58	
					QC 15 - 9	
140	Crosstubes - 2 - B4B	1 pcs	4/19/19	0.00 3.47	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
150	Crosstubes - 3 - B4B	1 pcs	4/19/19	0.00 0.91	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
160	QC 7	1 pcs	4/19/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
170	QC 5	1 pcs	4/19/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	

				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180	Outsource - 2 - NDT per QSI038	1 pcs	4/19/19	SKY002-VC	2
190	Packaging 2-1 - Receive - B4B	1 pcs	4/19/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
200	QC 6	1 pcs	4/19/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
210	Spray Paint - 2 - B4B	1 pcs	4/19/19	0.00 1.39	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
220	QC 14	1 pcs	4/19/19	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51

						QC 14 - 58	
						QC 14 - 59	
						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	
						QC 14 - 19	
230	Crosstubes - 4 - B4B	1 pcs	4/19/19	0.00	3.47	Crosstubes - 1 - B4B	
						Crosstubes - 2 - B4B	
						Crosstubes - 3 - B4B	
						Crosstubes - 4 - B4B	
240	QC 5	1 pcs	4/19/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
250	Packaging 1-1 - Pick Kit - B4B	1 pcs	4/19/19	0.00	0.00	Packaging 1 - 1 - B4B	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
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						Packaging 1 - 12 - B4B	
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						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
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						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	
						Packaging 1 - 22 - B4B	
						Packaging 1 - 23 - B4B	
						Packaging 1 - 24 - B4B	
						Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	
						Packaging 1 - 28 - B4B	
						Packaging 1 - 29 - B4B	
						Packaging 1 - 30 - B4B	
						Packaging 1 - 31 - B4B	
						Packaging 1 - 32 - B4B	

				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36	
260	QC 4	1	4/19/19	0.00 0.00	QC 4 - 28
		pcs			QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
270	Packaging 3-1 - Stock - B4B	1	4/19/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
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					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
275	DC - 1 - B4B	1	4/19/19	0.00 0.00	DC - 1 - B4B
		pcs			DC - 2 - B4B
280	QC21-FG	1 Ea	4/19/19	0.00 0.00	QC21

Part Op 110 - (Pick Kit)

Descriptions: 120 - (CNC Delta 100 Bender) 1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio 21

130 - (QC15- Crosstube Dimensional Check)

140 - (Crosstubes) ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED

BY: ***** 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245 2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D407-667-245. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes. Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245 5-Drill aft rivet holes using drill Jig DT8787 aft as per Dwg D407-667-245. Drill only the top (2) holes. 6- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for

paint. 8-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***Debur & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-245

150 - (Crosstubes Chemical Conversion) ***IMMEDIATELY AFTER GRINDING***

160 - (QC7-Inspect Chemical Conversion Coat)

170 - (QC5- Inspect part completeness to step on W/O)

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 0380

190 - (Receive & Inspect for Damage & Mat'l Certs) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

200 - (QC6- All purchased or subcontracted products) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - (Spray Paint / NDT Room) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside and outside crosstube as per DEO D407-667-245 and QSI 005 4.2 ***Mask underside of crosstube as shown*** 3- Apply clear coat as per dwg Clear Coat Batch:

220 - (QC14- Inspect Spray Paint) Then,Wrap in plastic bag to protect from scratches

230 - (Crosstubes) 1- Install chafing shield as per D407-667-245 using DT10096 to establish 8.90 dimension. Top holes should be facing up. ****Ensure chaffing is to be position "overlap" AFT**** A/R Proseal 890 Batch: EXP: 2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe 3-Install support with Scotch-Weld DP460 and install clamps as per Dwg D407-667-245 using installation jig DT9025. Torque clamps as per dwg A/R Scotch-Weld DP460 Batch: EXP: ****LET CURE FOR 24 HOURS*** CURE TIME: START: FINISH: 4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

240 - (QC5- Inspect part completeness to step on W/O) ***RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURE FOR 24HOURS AS PER DWG DEO***

250 - (Pick Kit)

260 - (QC4- 100% Inspect kits for completeness)

270 - (Identify as per dwg & Stock Location:) Identify and in kanban rack

275 - (Document Control) Photocopy bluefile and create labels as per PPP D407-667-205 CHG009

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D407-667-205TRN	Crosstube Turning Detail	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5150377
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes - 4 - B4B	
D2873-045	Nut Plate Assembly	2 pcs (2 ea)	230-Crosstubes - 4 - B4B	
D2894-1	2.75 Support	1 pcs (1 ea)	230-Crosstubes - 4 - B4B	
D3190-1	Chaffing Shield	2 pcs (2 ea)	230-Crosstubes - 4 - B4B	
D3595-063-430	Rubber Cushion 0.63" Wide X 4.30" Long	2 pcs (2 ea)	230-Crosstubes - 4 - B4B	
MS20601-AD4W8	Rivet	14 Ea (14 ea)	230-Crosstubes - 4 - B4B	
MS21920-22	Clamp	4 Ea (4 ea)	230-Crosstubes - 4 - B4B	
MS21920-25	Clamp	2 Ea (2 ea)	230-Crosstubes - 4 - B4B	
NAS1149D0563J	Washer	18 Ea (18 ea)	230-Crosstubes - 4 - B4B	
AN5-10A	Bolt	10 Ea (10 ea)	250-Packaging 1-1 - Pick Kit - B4B	
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	
AN5-34A	Bolt	4 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	
MS21042L5	Nut	4 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	

Job Allocations

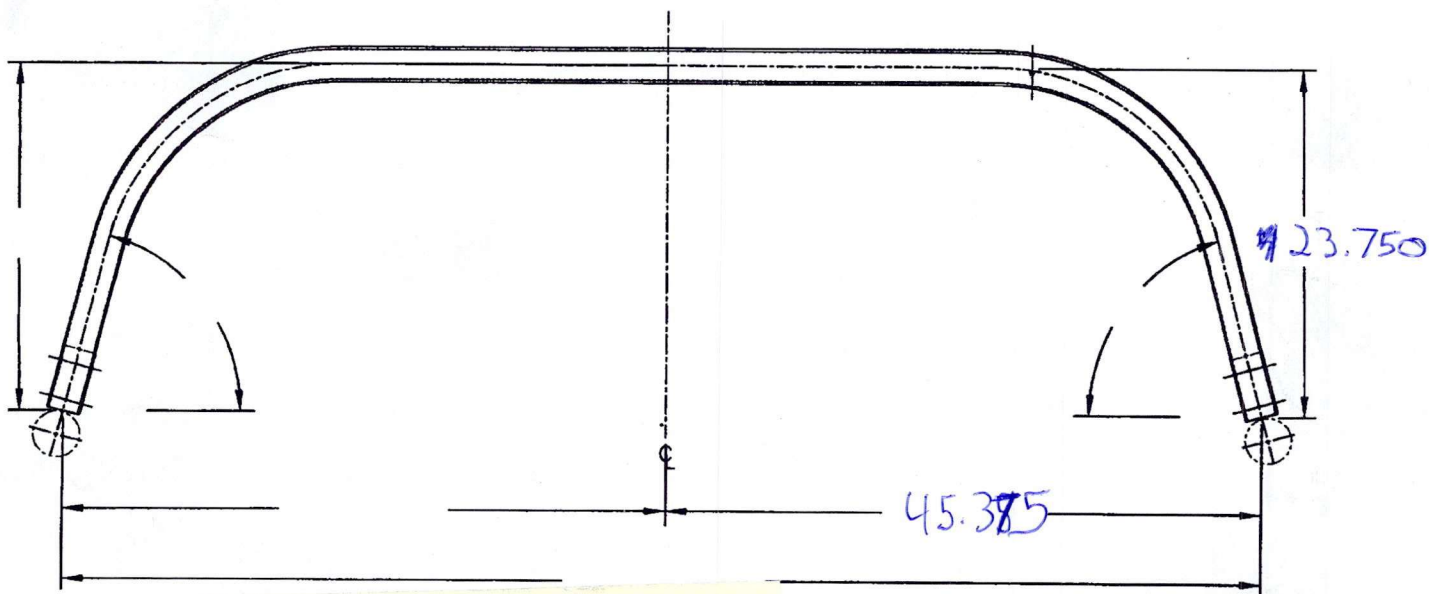
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D407-667-205TRN	1	2	0
230-Crosstubes - 4 - B4B	D2873-043	2	75	0
	D2873-045	2	42	0
	D2894-1	1	2	0
	D3190-1	2	53	0
	D3595-063-430	2	24	0
	MS20601-AD4W8	14	182	0
	MS21920-22	4	41	0
	MS21920-25	2	139	0
	NAS1149D0563J	18	1,477	0
250-Packaging 1-1 - Pick Kit - B4B	AN5-10A	10	340	0
	AN5-32A	4	385	0
	AN5-34A	4	39	0
	MS21042L5	4	709	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD	Work Order: 192288
Description: Crosstube High Aft (407)	Part Number: D407-667-205
Inspection Dwg: D407-667-245 Rev: G	Page 1 of 1

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	45.79	46.05
Angle	54	56
Total Span	91.58	92.100
Bending Passes	6	--
Crushing	--	6%



SCRAP.

Side B

Rev	Date		Revised by	Approved
A	07.02.0		KJ/JM	
B	09.06.2		KJ	
C	11.08.2		KJ	
D	11.09.30	Dimensions updated	KJ	
E	12.04.16	Added bending, crushing dimensions	KJ	
F	15.05.14	Dwg Rev updated	KJ	

8 7 6 5 4 3 2 1

Item	QTY -245	PART NUMBER	DESCRIPTION
	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
1	1	D6011-115	CROSSTUBE
2	2	D2873-043	NUT PLATE
3	2	D2873-045	NUT PLATE
4	1	D2894-1	SUPPORT
5	2	D3190-1	CHAFING SHIELD
6	2	D3595-063-430	RUBBER CUSHION
7	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
8	4	MS21920-22	CLAMP
9	2	MS21920-25	CLAMP (OR MS21920-24)
10	AR	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD
11	AR	PROSEAL 890	SEALANT

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6011-115
FINISHED LENGTH = 112.91±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT CROSSTUBE PER DART QSI 005 4.2
FOR HATCHED AREAS (ZN A6-2), MASK AS REQUIRED
TO APPLY PRIME AND APPLY CLEAR COAT ONLY
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 27.7 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 8% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2894-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3190-1 CHAFING SHIELDS AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEAL D3190-1 CHAFING SHIELDS ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS 50 TO 70 DEGREES FROM BOTTOM OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.
- TORQUE CLAMPS 80 TO 100 IN-LB. TORQUE CLAMPS ON D3190-1 CHAFING SHIELD 40 TO 50 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

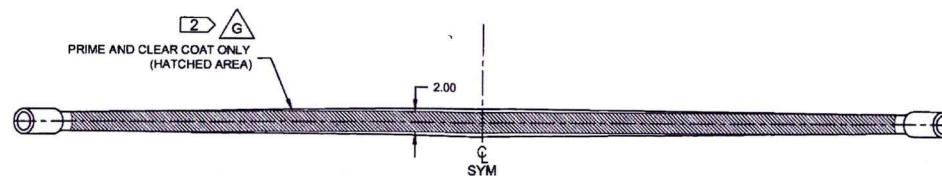
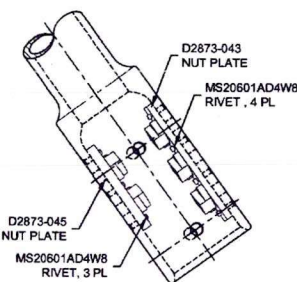
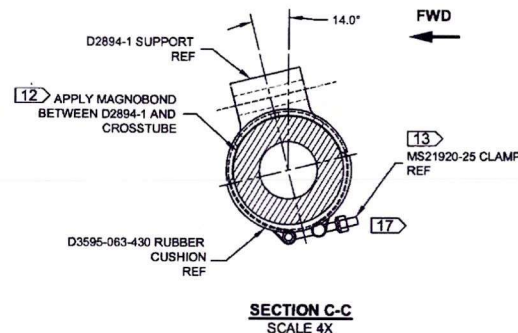
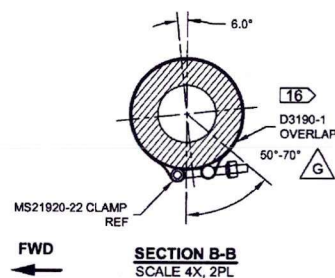
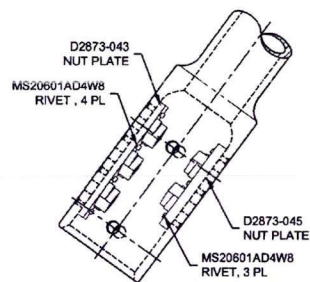
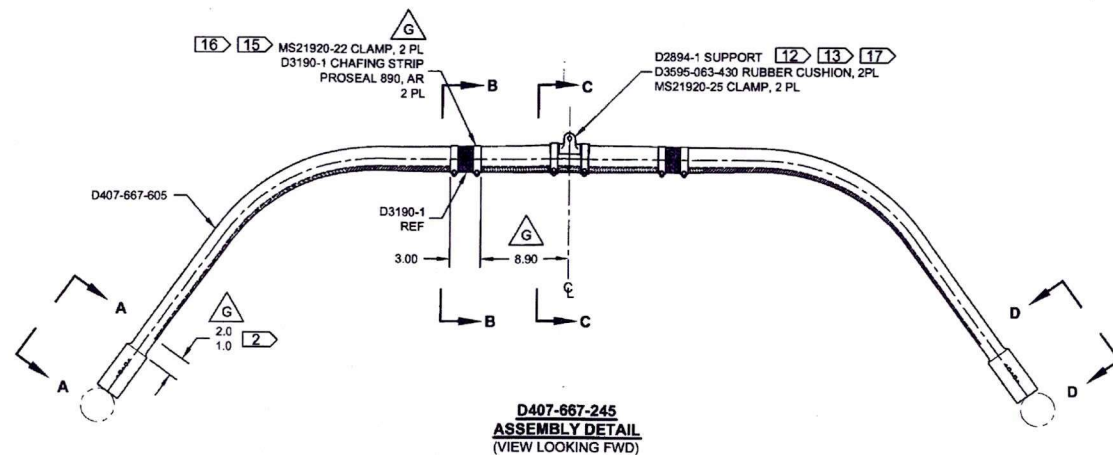
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192288 MJS
19-03-20

G	INCOMP. DEO'S D407-667-245-F1/F2 (ZN D8-1, A8-1, D5-2, B6-2, C6-2); 8.90 WAS 8.53 (ZN D5-2); TORQUE REDUCED FOR CHAFING SHIELD (ZN A8-1); FINISH REVISED TO ALLOW MANUFAC. FLEXIBILITY (ZN C6-1)	RF	15.03.20
F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	15.03.20		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D407-667-245 SHEET 1 OF 4 TITLE CROSSTUBE ASS'Y (407 HIGH AFT) SCALE NTS COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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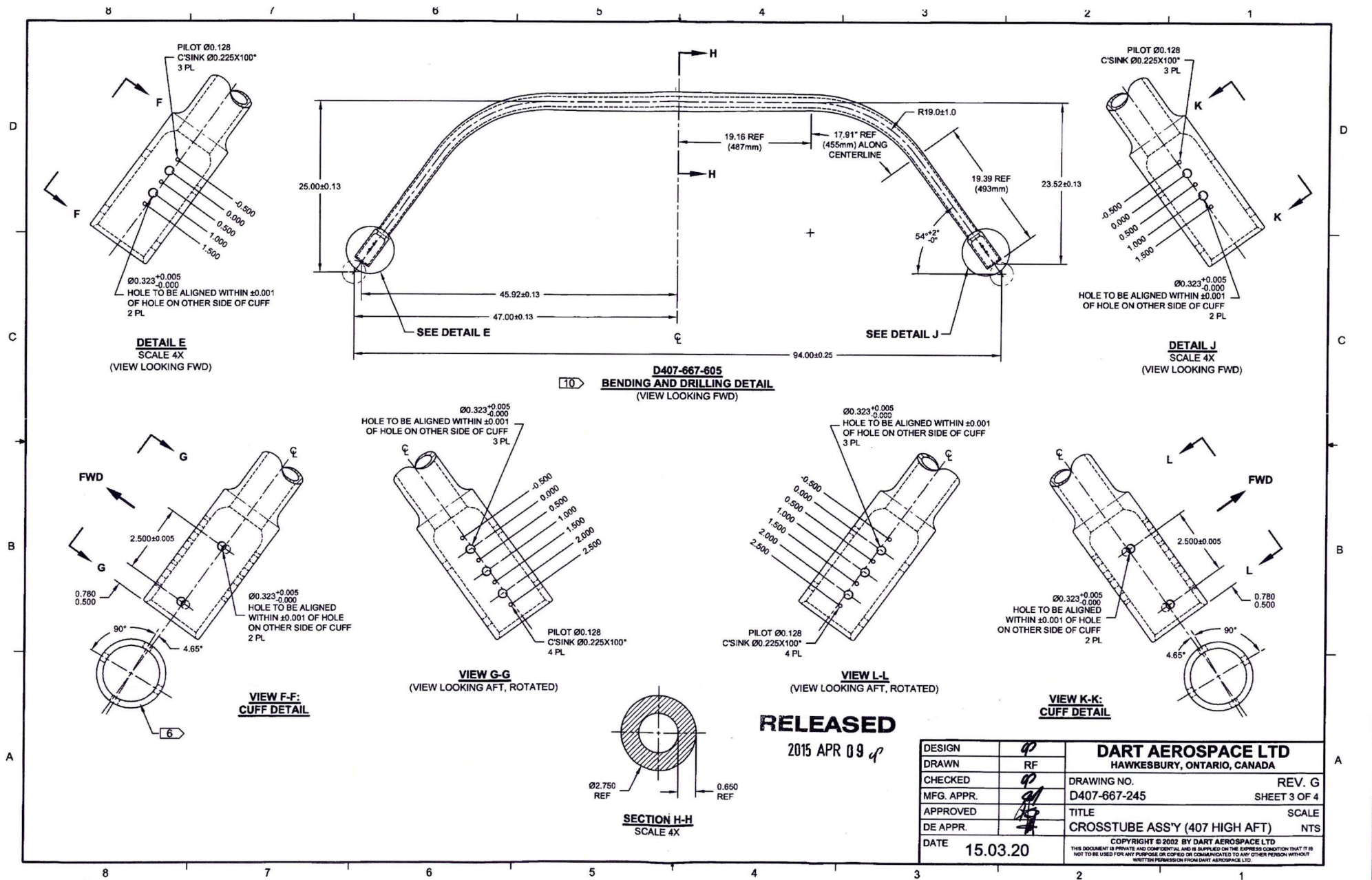
2015 APR 09
ECN 15-557

8 7 6 5 4 3 2 1



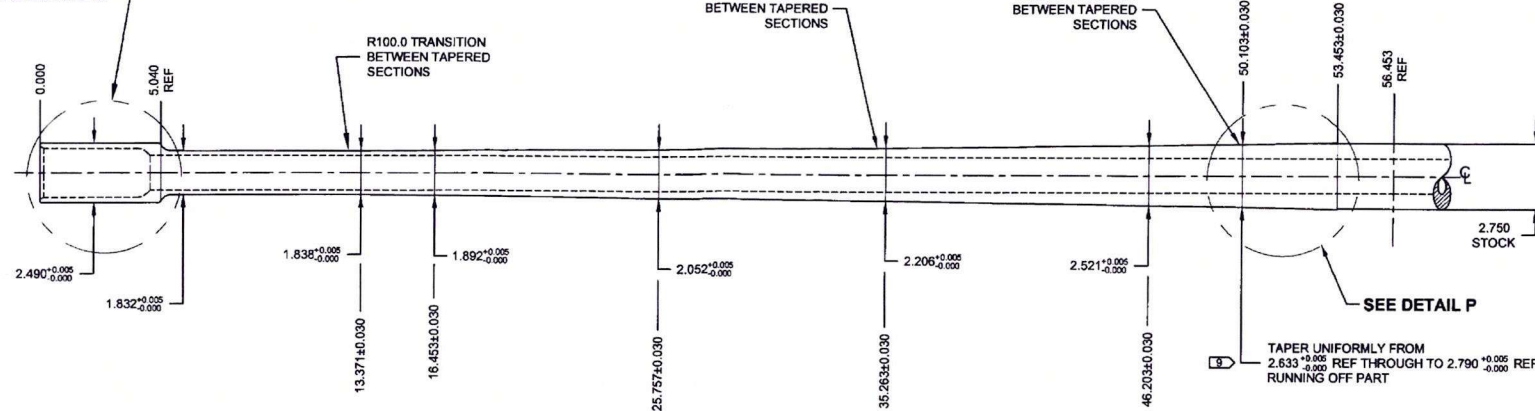
RELEASED
2015 APR 09

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9P	DRAWING NO.	REV. G
MFG. APPR.	9P	D407-667-245	SHEET 2 OF 4
APPROVED	9P	TITLE	SCALE
DE APPR.	9P	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
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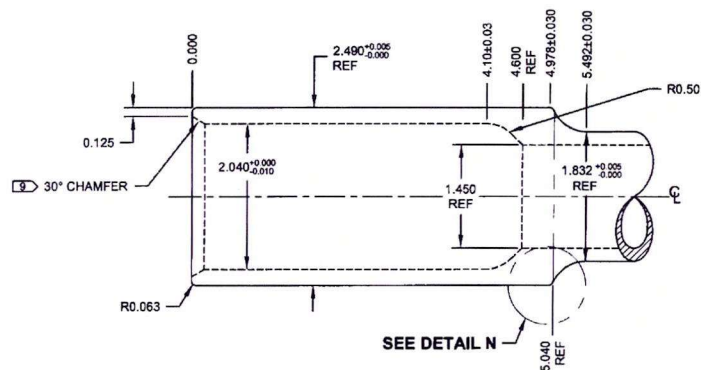


DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. G
MFG. APPR.	90	D407-667-245	SHEET 3 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
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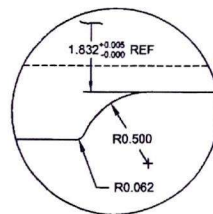
SEE DETAIL M



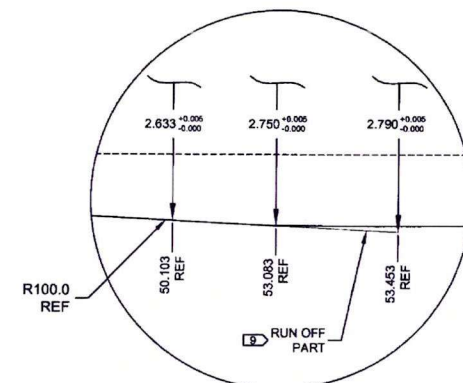
D407-667-245 MACHINING DETAIL



DETAIL M: CROSSTUBE CUFF
SCALE 3X



DETAIL N: CUFF TRANSITION
SCALE 2X



DETAIL P: TAPER RUN-OFF
NOT TO SCALE

RELEASED
2015 APR 09

DESIGN	Q	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	Q	DRAWING NO.	REV. G
MFG. APPR.	Q	D407-667-245	SHEET 4 OF 4
APPROVED	Q	TITLE	SCALE
DE APPR.	Q	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>192288</u> Part No. <u>D407-667-205</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☒ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date : _____	Sequence #: <u>130 QC15</u>	QTY Affected : <u>1</u>		MRB (QSI042)
Description Work Order Deviation		Disposition		
- HEIGHT MAX: 23.65" ACTUAL : 23.75" - 1/2 SPAN MIN: 45.79" ACTUAL : 45.375"		SCRAP		Completed By DAS 68 9-89
				Lead hand / Supervisor
				QC / QA Coordinator DAS 68 9-89 MAY 07 2019
Root Cause Operator ☒ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				